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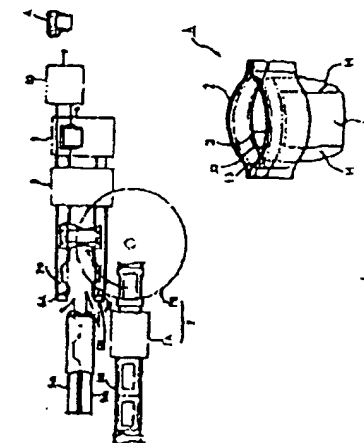
(54) MANUFACTURE OF BRIEFS TYPE DISPOSABLE
DIAPER

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(57) Abstract:

PURPOSE: To reduce costs by enabling an automatic large-scale production method by forming a back body wrapping part and front body wrapping sections to place a diaper main body thereon orthogonally and to bond it thereto.

CONSTITUTION: Optional stock is selected for a back body wrapping section and front body wrapping sections (2 and 3) independently of diaper body 1. In other words, the diaper body 1 is relayed to a turning transfer device 7B behind a suction conveying device 7A and the diaper body 1 is turned by 90° to be supplied to a specified position between belt bodies 2a and 3a of both body wrapping sections perpendicular thereto. Then the diaper body is conveyed to a bonding means 8 to bond it integrally with the belt bodies 2a and 3a of both body wrapping sections. Thereafter, the assembly is conveyed to a folding means 9 to be folded double and side ends of the belt bodies 2a and 2b of both the body wrapping sections are cut while being bonded by a bonding/cutting means 10.



*full translation attached
No equivs. outside Japan*

Translation of
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Title of the invention Brief-type disposable diaper production
method

Patent application number H1-315742

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Specification

1. Title of the invention

Brief-type disposable diaper production method

2. Scope of the patent claim

A brief-type disposable diaper production method involving

a process whereby a water-absorbent material is inserted between an outer sheet and an inner sheet to form a diaper body;
a process whereby a front waistband and a continuous back waistband having an elastic member at least at the side is formed;

a process whereby the diaper body is overlapped and adhered to both waistbands in the transverse direction;

a process whereby the diaper body is folded double and both waistbands are brought into contact; and

a process whereby the contacted waistbands are cut to prescribed dimensions and the regions near the cuts are adhered to integrate the waist parts at the edge portions

to produce a brief-type disposable diaper from a diaper body and a single waistband.

3. Detailed description of the invention

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Field of industrial use

The present invention relates to a brief-type disposable diaper production method.

Prior art

Known technology relating to this type of brief-type disposable diaper production method is disclosed in Japanese Unexamined Patent Application Number S57-77304: "Diaper-brief and Production Method Therefor".

Problems to be overcome by the invention

The abovementioned technology is disadvantageous in that as there is a cut-out portion in order to form an opening for the wearer to insert his/her legs, it is necessary to add a process for forming the cut-out portion, which raises production costs.

Means of overcoming the abovementioned problem

The present invention overcomes the abovementioned problem of the prior art and allows the production of brief-type disposable diapers by an automated large-scale production method involving a process whereby a diaper body is formed; a process whereby a back waist part and front waist part are formed; a process whereby the diaper body is overlapped and adhered to both waist parts in the transverse direction; and a process whereby the diaper body is adhered and integrated.

Embodiment

The present invention is described in detail based on the embodiment shown in the following drawings.

Figures 4 through 6 show an example of a brief-type disposable diaper produced according to the present invention: 1

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represents the diaper body, formed by inserting absorbent material 13 between outer sheet (for example, a water-impermeable P.E. sheet) 11 and inner sheet (for example, water permeable nonwoven cloth) 12.

2 is the back waist part and 3 is the front waist part, and the material for both waist parts 2 and 3 may be selected independently from the material for diaper body 1, although in this embodiment, the same material is used; the double layer having P.E. sheets 21 and 31 as the outside and nonwoven cloth 22 and 32 as the inside is formed, an elastic member sheet (for example, a polyurethane sheet) 23 and 33 is inserted into part thereof, so that at least the upper edge is expandable. It should be noted that it is also possible to have a single layer elastic sheet, to form a completely expandable construction. It should be noted that as waist parts 2 and 3 are preferably of an air-permeable material, it is desirable either to take the nonwoven cloth and elastic sheet, and exclude the P.E. sheet, or, when a P.E. sheet is used, to puncture a plurality of small holes therein. It is also possible to totally or partially affix the elastic member (rubber thread, rubber tape or the like) to a sheet of suitable material, to form an elastic sheet.

Moreover, the hole parts H for the insertion of the wearer's legs are dictated by the width and shape of the diaper body 1 and the width and shape of waist parts 2 and 3, and generally, the shape is such that the holes are toward the front side.

The brief-type disposable diaper production method of the

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present invention will be described below with reference to Figures 1 through 3.

Figure a shows the diaper body 1 production process: absorbent body 13 is placed on outer sheet (back sheet) 11 supplied from outer sheet roller 11a, then inner sheet (top sheet) 12, supplied from inner sheet roller 12a, is supplied thereon, to achieve a sandwich-like insertion of absorbent body 1 between outer sheet 11 and inner sheet 12; then this is transported by the first conveyor device 4 to adhering-cutting device 15, and the circumference is firmly adhered by adhering-cutting device 15, or adhered with adhesive, then cut to the required shape. It should be noted that this process is the same as known diaper production processes, and it is possible to employ a conventional production line for disposable diapers.

It should be noted that the adhering-cutting device 15 comprises two stages: first unit 15a and second unit 15b. In first unit 15a, only adhesion and the cutting of cut-away parts P proceeds, to continuously form diaper body 1, then diaper body band 1a is transported to the next process, and may be cut crosswise to the required dimensions by second unit 15b when in the vicinity of the waistbands 2,3-adhesion process.

Moreover, as there are no cut-away parts P when diaper body 1 is long, it is also possible to achieve the aims of the present invention by only adhering in first unit 15a, then cutting in second unit 15b.

There are various possible shapes for the cut-away parts P, and the shape can be selected according to the shape of the

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waistband 2,3 and the desired shape of hole parts H.

Figure 1(b) shows a waistband 2, 3 production line: elastic member sheet 23a, supplied by elastic member sheet roller 14, is cut along a continuous S-shaped cutting line in the central portion by cutting device 24 to form a pair of bands, back waistband 2a and front waistband 3a.

It should be noted that in the case of the multilayer constructions shown in Figure 3 (outer sheet (P.E. sheet) and elastic member sheet, inner sheet (nonwoven cloth) and elastic member sheet, or outer sheet and elastic member sheet-inner sheet), if elastic member sheet 23a is a band of the same width, and only part of sheet 21a, 22a is adhered, the elastic member sheet can be used effectively without cut-away parts, and holes of the desired shape can be found by selecting a suitable shape for waist part 2,3.

Figure 1(c) integrates the diaper body 1 process of Figure 1(a) and the waistband 2a, 3a process of Figure 1(b), to show the brief-type disposable diaper-forming process: the second conveying device 5a, 5b for waistbands 2a, 3a extends to become the third conveying device 6A and the force conveying device 6B.

Diaper body supply means 7 comprises suction conveying device 7A and rotation conveying device 7B, such that suction conveying device 7A for conveying the diaper body 1 that has been cut to the required dimensions is provided at the end of the first conveying device 4, after which diaper body 1 proceeds onto rotation conveying device 7B, then rotation conveying device 7B rotates the diaper body 1 through 90°, to supply diaper body 1

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transversely to a prescribed position on waistband 2a, 3a.

It should be noted that rotation conveying device 7B receives the diaper body 1 on the conveying surface of suction conveying device 7A then supplies it by rotating $1/4$ of a rotation while suction continues, then rotating the diaper body 1 that is between third conveying device 6A and fourth conveying 6B through 90° , and diaper body supply means 7 can achieve the aim by means of a suitable conveying means as follows: the adsorption surface of the diaper body is rotated through 90° according to the rotation of a suction rotation drum provided so as to be continuous with suction conveying device 7A, then the diaper body proceeds to a suction conveyor belt, whereupon it is conveyed in a transverse direction with respect to the conveying devices, thereby allowing diaper body 1 to be supplied between waistbands 2 and 3.

Diaper body 1 is then conveyed to adhesion means 8 and adhered to waistbands 2a, 3a by a suitable adhesion means such as an adhesive or heat seal.

It is then conveyed to folding means 9, and folded double by said folding means 9 to superimpose front waistband 2a and back waistband 3a.

The sides of the superimposed waistbands 2a and 2b are adhered and cut to the required shape by adhering-cutting means 10, to yield brief-type disposable diaper A.

Advantages of the invention

The present invention yields a brief-type disposable diaper by adhering and integrating a pair of waistbands and a

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diaper body and cutting to the required dimensions and so conventional diaper production lines can be used for the diaper body, the waist parts are supplied as bands and automated mass production is possible due to a belt conveying device, so the brief-type disposable diapers can be effectively produced at extremely low cost.

4. Brief description of the drawings

Figure 1 is an explanatory diagram for the brief-type disposable diaper production method of the present invention: Figure (a) shows the diaper body production process, and Figure (b) shows the waistband-integrating process.

Figure 2 is a diagram of the diaper body, and Figure 3 shows the front waist part and back waist part.

Figure 4 shows an oblique view of a brief-type disposable diaper produced according to the present invention, Figure 5 is plane view and Figure 6 is a cross-sectional view of the diaper body.

- | | |
|----|--------------------------|
| 1 | Diaper body |
| 2 | Back waist part |
| 3 | Front waist part |
| 7 | Diaper body supply means |
| 8 | Adhesion means |
| 9 | Folding means |
| 10 | Cutting means |

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④ 特許出願公開

④ 公開特許公報(A)

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否並請求 未請求 請求項の数 1 (全6頁)

④ 発明の名称 プリーフ形使い捨ておむつの製造方法

④ 特 願 平1-315742

④ 出 願 平1(1989)12月4日

④ 発 明 者 和 田 隆 男 大阪府堺市南別府町15番21号 株式会社瑞光内

④ 出 願 人 株 式 会 社 瑞 光 大阪府堺市南別府町15番21号

④ 代 理 人 弁 理 士 長 村 文 彦

要 約

1. 発明の名称

プリーフ形使い捨ておむつの製造方法

2. 発明の要旨

外装シートと内装シートとの間に吸水部を設け、
 込んでおむつ本体を形成する工程と、

少なくとも側面部に側面部材を設ける工程との
 両側面部材吸水部を設け、側面部材吸水部を
 形成する工程と、

両側面部材吸水部と吸水部内に設けられた吸水部を
 接合する工程と、

おむつ本体を二層に折り畳むとともに両側
 面部材吸水部を接合させる工程と、

折り畳んだ両側面部材吸水部を接合するに折返し
 込む両側面部材の端部を接合して両側面部材吸水部を
 一体化する工程と、

を特徴とする、おむつ本体と、一体化両側面部材
 により、プリーフ形使い捨ておむつを製造するこ
 とを特徴とする、プリーフ形使い捨ておむつの製
 造方法。

3. 発明の利便性効果

○ 従来の技術的課題

本発明は、プリーフ形使い捨ておむつの製造方
 法に関するものである。

○ 発明の目的

この発明のプリーフ形使い捨ておむつの製造方法
 によれば、特許第31-71304号「おむつのプリー
 フおよびその製造方法」の技術的課題が克服する。

○ 発明が解決すべき課題

上記の従来の技術的課題においては、側面にあり側
 面の吸水部を設けるための開口部を形成するための
 側面部材が存在するので、側面部材を形成するた
 めの工程を削減する必要がある、製造コストが相
 対的に高くなる。

○ 上記課題を解決するための手段

本発明は、おむつ本体を形成する工程と、両側
 面部材吸水部および側面部材吸水部を形成する工程と、
 両側面部材吸水部と吸水部内に設けられた吸水部を接
 合する工程と、おむつ本体を二層に折り畳む工
 程とにより、両側面部材吸水部によりプリーフ

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ブリーフ形に用いておこつとせる工程を示し、bの図は側面図、cは図2a・3aの第2製造工程3a・3bを従て第3製造工程6aおよび第4製造工程6bとする。

第1製造工程4の終極に、所定寸法に切断されたおこつ本板1を搬送するための吸引搬送装置7Aを用い、その後方の従動移送装置7Bにおこつ本板1を引寄せ、従動移送装置7Bでおこつ本板1を90度回転させて側面図に示す図2a・3aの所定位置に搬送位置でおこつ本板1を供給して、おこつ本板供給手段7を構成する。

なお、従動移送装置7Bは吸引搬送装置7Aの搬送面上のおこつ本板1を受け取り、吸引しつつ1/4回転して第3製造工程6aと第4製造工程6bとの間におこつ本板1を90度回転させて供給するものであるが、吸引搬送装置7Aに直接して吸引回転ドラムを用いてドラムの回転に伴っておこつ本板の吸着面を回転させて90度回転させたのち吸引移送ベルトに引寄せ吸引移送ベルトで搬送装置と搬送方向に付送しても、本板おこつ

1を側面図より図2a・3aに示す通りであり、おこつ本板供給手段7は搬送の搬送手段により目的を達成することができる。

次に所定手段8へ搬送した後、ヒートシール、接着剤等の接着の搬送手段により、本板おこつ1を側面図より図2a・3aと側面して一体化する。

そのうち、所定手段8へ搬送し、所定手段8により二部材に側面図より図2aと所定側面図より図2aとを吸着合わせ、

吸着合わせた側面図より図2a・2bの側面図を、所定側面図より図2aにより接着するとともに、所定寸法に切断して、ブリーフ形に用いておこつ人を完成する。

○発明の効果

本発明は、一列の側面図より図2a・2bの側面図とを、接着一体化し、所定寸法に切断することにより、ブリーフ形に用いておこつを完成するものであるから、おこつ本板は従来のおこつ製造ラインを利用することができ、また側面図より図2a

10—切取手段

出願人 株式会社 丸 光
代理人 弁護士 奥村 文雄

図で供給されることで、ベルト搬送装置による搬送の搬送方法とすることができ、おこつのコストでブリーフ形に用いておこつを提供できる効果を実現するものである。

1. 図面の簡単な説明

第1図は本発明によるブリーフ形に用いておこつの製造方法を示す説明図で、2図はおこつ本板の製造工程、3図は側面図との一体化工程をそれぞれ示すものである。

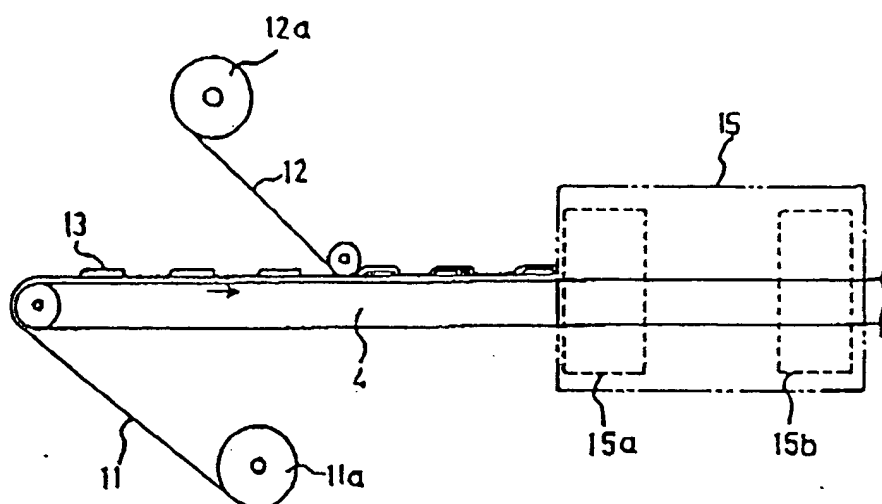
第2図はおこつ本板の説明図、第3図は側面図より図2aおよび側面図より図2bの説明図である。

第4図は本発明により製造されたブリーフ形に用いておこつの側面図、第5図は平面図、第6図は本板おこつの側面図である。

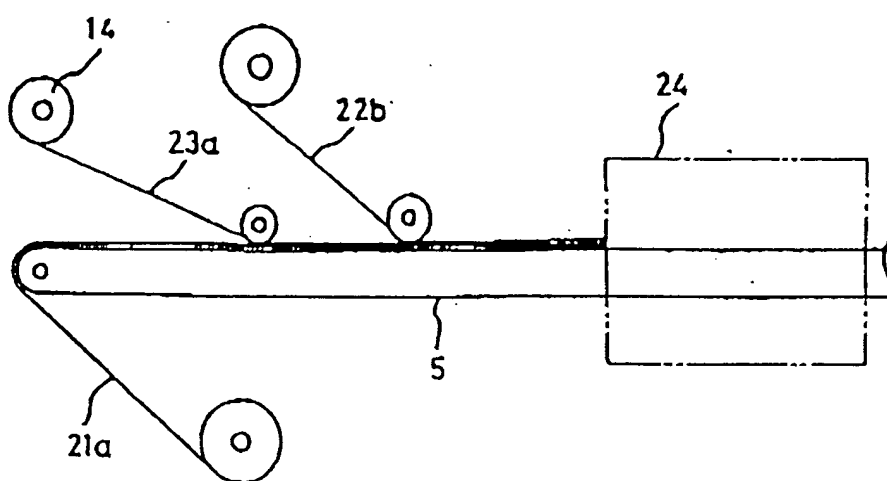
- 1—おこつ本板
- 2—側面図より図2a
- 3—側面図より図2b
- 7—おこつ本板供給手段
- 8—接着手段
- 9—所定手段

特開平3-176053(4)

第1図 (a)

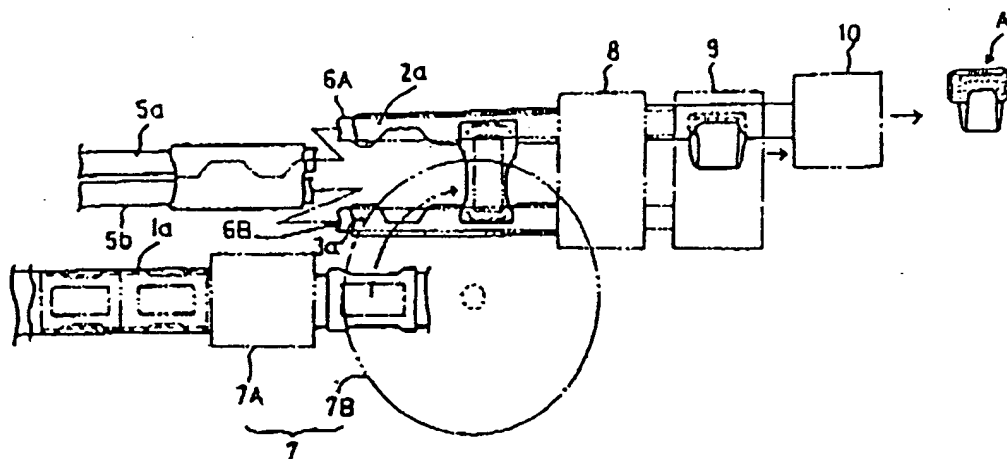


第1図 (b)

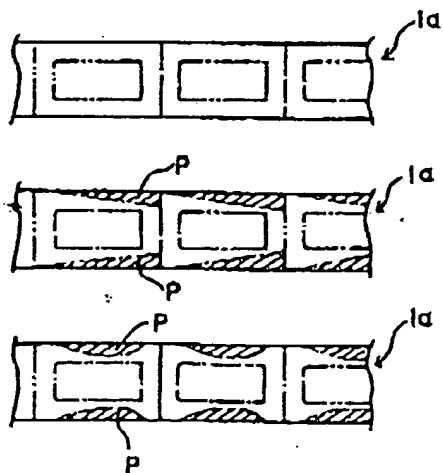


發明 3-176053 (5)

第 1 圖 (C)



第 2 圖



第 3 圖

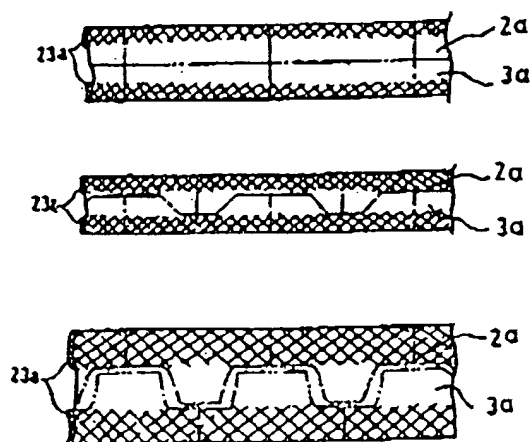
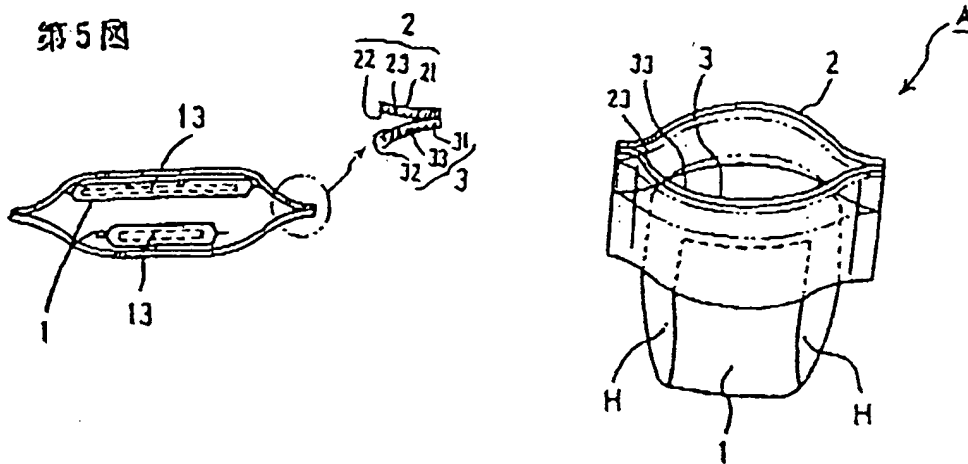


图 3-17053 (6)

第 4 图



第 6 图

